

Date:
User:Wednesday, 2/21/2007 10:27:27 AM
Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR INSTALLATION
Job Number	: 30783		
Estimate Number	: 12742		
P.O. Number	: N/A	Part Number	: EA2046928
This Issue	: 2/21/2007 S.O. No. : N/A	Drawing Number	: D20446901 REV 1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: 1
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u> 07-02-21	Due Date	: 2/28/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	8 Um: Each
Comment	: Est Rev:A New Issue 07-02-21 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NR0750 4130 steel rod .750"



Comment: Qty.: 0.0609 f(s)/Unit Total: 0.4872 f(s)
 4130 steel rod .750" 4130 steel rod .750" W .058"
 Batch: 103433

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
 Turn as per Dwg D2046901

SA 07.02.21 8

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.02.21 8

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SG 07.02.21 8

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

M 07/02/22 (8)

Date: Wednesday, 2/21/2007 10:27:28 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR INSTALLATION

Job Number: 30783

Part Number: EA2046928

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTIONW/O RELEASE



(2)

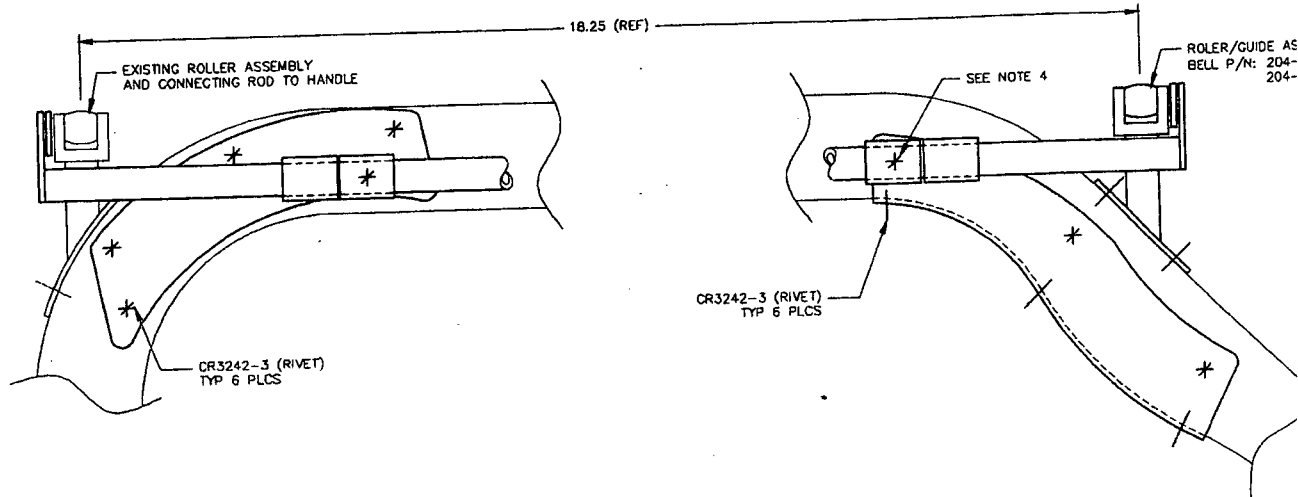
Comment: FINAL INSPECTIONW/O RELEASE

~~10762123~~

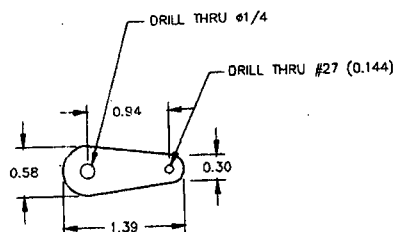
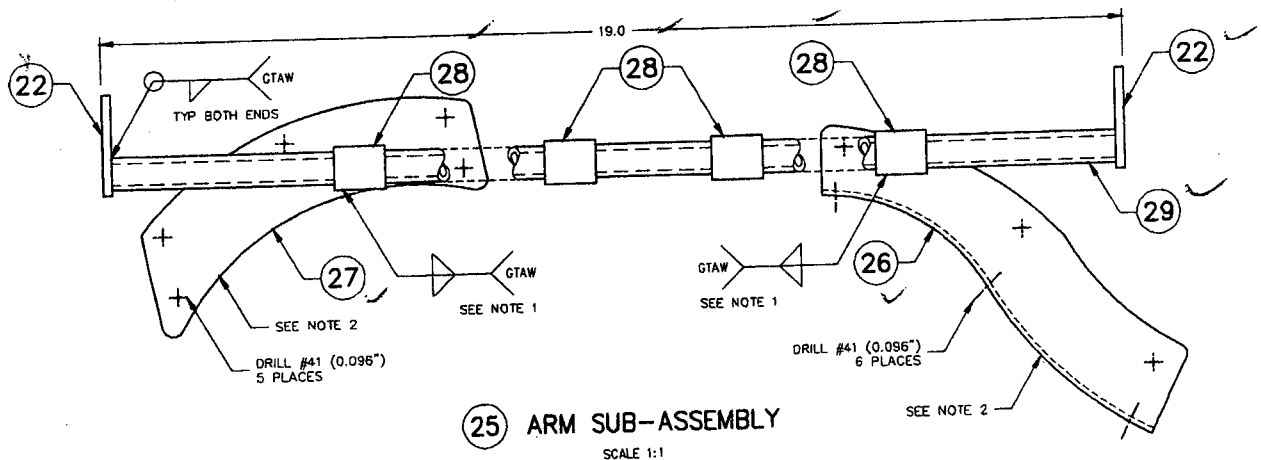
Job Completion



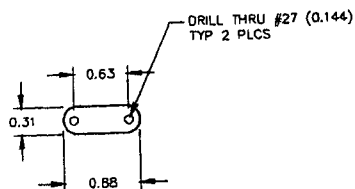
U 02-02-23



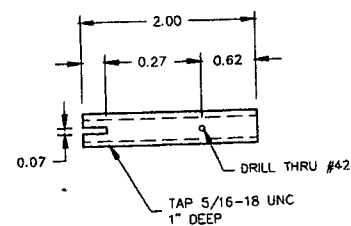
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



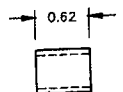
(22) LUG
SCALE 1:1



(23) LINK
SCALE 1:1



(24) ROD
SCALE 1:1



(28) ARM GUIDE
SCALE 1:1

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.

NOTE 4

ROLER/GUIDE ASSEMBLY
BELL P/N: 204-030-499-005
204-030-853-009

MS16997-22 (SCREW)

MS20426AD4 (RIVET)
MANUFACTURED HEAD FAR SIDE
ALLOW FOR ROTATION OF LINK

CR3242-3 (RIVET)
TYP 2 PLACES

GUIDE ASSEMBLY
BELL P/N: 204-030-853-009

- | QTY. | DASH NO. | DESCRIPTION | PART NO. | MATERIAL | MATERIAL SPEC. | STOCK SIZE |
|------|----------|---|------------|------------|----------------|------------------------|
| 1 | 29 | ARM | EA20468-29 | 4130 STEEL | MIL-T-6736 | #3/8 O.D. x 0.093 WALL |
| 4 | 28 | ARM GUIDE | EA20468-28 | 4130 STEEL | MIL-T-6736 | #1/2 O.D. x 0.063 WALL |
| 1 | 27 | DOOR PLATE | EA20469-27 | MILD STEEL | | 0.063" SHEET |
| 1 | 26 | DOOR PLATE | EA20469-26 | MILD STEEL | | 0.063" SHEET |
| 1 | 25 | ARM SUB-ASSEMBLY | EA20469-25 | | | |
| 1 | 24 | ROD | EA20469-24 | 4130 STEEL | MIL-T-6736 | #3/8 O.D. x 0.093 WALL |
| 2 | 23 | LINK | EA20469-23 | 4130 STEEL | MIL-S-18729 | 0.063" SHEET |
| 2 | 22 | LUG | EA20469-22 | 4130 STEEL | MIL-S-18729 | 0.063" SHEET |
| 1 | 21 | DOOR COVER PANEL | EA21469-21 | | | |
| | 20 | FLIGHT MANUAL SUPPLEMENT 214B, 214B-1 | EA21469-20 | | | |
| | 20 | FLIGHT MANUAL SUPPLEMENT 212, 412 | EA21269-20 | | | |
| | 20 | FLIGHT MANUAL SUPPLEMENT 205A, 205A-1 | EA20569-20 | | | |
| 1 | 20 | FLIGHT MANUAL SUPPLEMENT 204B | EA20469-20 | | | |
| 1 | 19 | EAGLE SERVICE INSTRUCTION | EA20469-19 | | | |
| 1 | 18 | DOOR INNER SKIN | EA20469-18 | | | |
| 1 | 17 | ANGLE | EA20469-17 | | | |
| 1 | 16 | ARM REST ASSEMBLY | EA20469-16 | | | |
| 1 | 15 | INSTRUMENT PANEL | EA20469-15 | | | |
| 1 | 14 | WINDOW RETAINER | EA20469-14 | | | |
| 1 | 13 | INSTRUMENT WINDOW | EA20469-13 | | | |
| 1 | 12 | FORWARD RIB | EA20469-12 | | | |
| 1 | 11 | ANGLE | EA20469-11 | | | |
| 1 | 10 | REARWARD RIB | EA20469-10 | | | |
| 1 | 9 | ANGLE | EA20469-09 | | | |
| 1 | 8 | PLACARD - INSTRUMENT PANEL | EA20469-08 | | | |
| 1 | 7 | ANGLE | EA20469-07 | | | |
| 1 | 6 | ALUMINUM STRIP | EA20469-06 | | | |
| 1 | 5 | RUBBER STRIP | EA20469-05 | | | |
| 1 | 4 | DOOR LATCH ASSEMBLY | EA20469-04 | | | |
| 1 | 3 | PLEXIGLASS BUBBLE WINDOW | EA20469-03 | | | |
| | 2 | INSTALLATION - DOOR MOUNTED INSTRUMENTS | | | | |
| | 1 | INSTALLATION - BUBBLE WINDOW | | | | |
- LIST OF MATERIALS

BASIC CODE		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, 2ND FLOOR 1545 McTAVISH ROAD N.E., CALGARY, AL. T2B 7G8	
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK		DASH NO. FOR LENGTH		DRAWN: E. BURGAIN		26 AUG 1991		EAGLE COPTERS LTD. 825 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2B 7G8 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION	
BASIC CODES:		* <input type="checkbox"/> INSTALL NEW RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				DWC SIZE	
BJ = MS20470AD		+ <input type="checkbox"/> REMOVE/REPLACE RIVET		DECIMALS		ANGLES		DWC NO.	
BB = MS20428AD				X.XXX ±0.010		±1/2"		A1	
LZ = NAST087AD				X.XX ±0.03				D2046901	
CX = MS20470DD		- <input type="checkbox"/> EXISTING RIVET		X.X ±0.1				REV.	
						SCALE AS NOTED		1	
						SHEET 3 OF 3			

